

Work Order ID 74680

Wednesday, October 05, 2011 8:58:32 AM

Page 1

Item ID: D6101-003

Accept

Revision ID:

Item Name: Saddle Billet, 7075

Start Date: 10/5/2011 Start Qty: 80.00

Required Date: 10/28/2011 Req'd Qty: 80.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15095

a) Description: Alluminum Billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

11-10-5
80

Rec'd 10/14/11 (80)

Work Order ID 74680

Wednesday, October 05, 2011 8:58:32 AM

Page 2

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Accept

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Approvals: Process Plan:

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

130

Identify as per dwg & Stock Location: 1144

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



OK 11/10/19

80

8

OK 11/10/19

80

8

11/10/19

MF 11-10-19

Picklist Print

Wednesday, October 05, 2011 8:58:30 AM

Page 1

Work Order ID: 74680

Parent Item: D6101-003

Parent Item Name: Saddle Billet, 7075



Start Date: 10/5/2011

Required Date: 10/28/2011

Start Qty: 80.00

Required Qty: 80.00

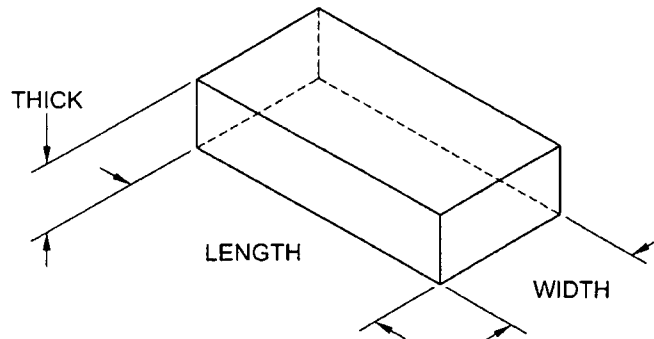
Comments: IPP A: 01.05.04 New Issue IEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P		Purchased	No			110	Each	0.0000	1	80			
7075-T7351 2X6.25X7.875													



Per/pj/y (80)

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

B I L L O F L A D I N G

No: PEC 733537
Ship Date 14Oct11 at 16:50 From PFW

Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-376093- 1 Your PO # 15095
ALUMINUM PLATE 7075T7351
2.00" THICK X 6.0000" X 6.2500"

*****D6101-001*****

Heat Number	Tag No	Quantity	PCS	Wt LBS
708281	241823	20.83 SFT	80	623

2) Our Order PEC-376093- 2 Your PO # 15095
ALUMINUM PLATE 7075T7351
2.00" THICK X 6.2500" X 7.8750"

*****D6101-003*****

Heat Number	Tag No	Quantity	PCS	Wt LBS
708281	241825	27.34 SFT	80	814

TOTAL:	Tags	PCS	LBS
	2	160	1437

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **

TOTAL (1,2) 2 SKIDS GW. 1648 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ETRE
RAPPORTEES IMMEDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G
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Ship Date 14Oct11 at 16:50 From PFW
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Route 0- 0 Manifest
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Slp STAN IVERS (905-532-1350)
Sold To: (20115)
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1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

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2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

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No: PEC 733537
Ship Date 14Oct11 at 16:50 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

Ship To: (1)
DART AEROSPACE

B I L L O F L A D I N G

* WE STOCK STAINLESS STEEL *
* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 2 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.
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MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
TVQ/GST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

SHIP FROM:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (1)
DART AEROSPACE

NO: PEC 733537
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Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

B I L L O F L A D I N G

* WE STOCK STAINLESS STEEL *
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REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein. Including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Valcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292848	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2011-09-26	6375246	00000	1000320482-5	DS-20482-02-2
P.O. No./Govt Contract No.	Customer	Alcoa Item		
5400113144 Ln#: 0030	COPPER & BRASS SAL G041120093R04			

Page 1 of 2

Ship To: COPPER & BRASS SALES INC
FRESNO BRANCH
5450 E HOME
FRESNO 93727 CA

Item Description
2.0 IN TK (+.055 -.055) X 52.5 IN W (+.3125 -
0.000) X 144.5 IN LN (+.5 -0.0) (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED. AMS-QQ-A-250/12 IS 2007 EXC_MRK AMS-STD-
2154 IS 2010 EXC_MRK AMS407B REV G EXC_MRK
ASTMB209 REV 10 EXC_MRK BSS7055 REV A EXC_MRK
MMS159 REV P ((MARKED)) KRAFT PAPER
INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-40 % US1 CL
A 3 MM CQR 0231073 REV 02 CUST REQ 11-09-
27 *** W/E 11-10-01 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	338534	708281	3093	2	PC	47111
2	338536	708281	3093	2	PC	47111
3	338537	708281	3097	2	PC	47111
4	338548	708281	1550	1	PC	47111
			10833	7		

Notes for CQR: 0231073.2

PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: 0231073.2 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	57.0	6

MADE BY ThyssenKrupp
COPPER NO. 2401490407
BY J.R.
COPPER & BRASS SALES INC

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

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Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292848	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2011-09-26	6375246	00000	1000320482-5 DS-20482-02-2
P.O. No./Govt Contract No.	Customer	Alcoa Item	
5400113144 Ln#: 0030	COPPER & BRASS SAL G041120093R04		

Page 2 of 2

CQR: 0231073.2 -Specification Limits (cont.)
T7351 Elec. Cond. (EC) % MIN 38.0 PCT

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Lot: 708281	Min		1.2		2.1	0.18	5.1				

Mechanical, Physical, Metallography, Quantometer Results

Test	UTS	TYS	EL4D
T7351 Long Transv.	71.4	60.8	10.6
	71.3	60.7	10.5
	71	60.3	10.5

T7351 Elect Cond %IACS 41.2 41.5 41.3 PCT

Cast Number	Chemical	OBS	SI	FE	CU	MN	MG	CR	ZN	TI
H9370105	Actuals		0.08	0.30	1.6	0.02	2.5	0.18	5.6	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.972.1(a)]; it was manufactured in the United States

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

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For

Valcolm Murphy

Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292846

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

2011-09-26

6375246

00000

1000320482-5

DS-20482-02-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

5400113144 Ln#: 0030

COPPER & BRASS SAL G041120093R04

Page 1 of 2

Ship To: COPPER & BRASS SALES INC

FRESNO BRANCH

5450 E HOME

FRESNO 93727 CA

Item Description

2.0 IN TK (+.055 -.055) X 52.5 IN W (+.3125 - 0.000) X 144.5 IN LN (+.5 -0.0) (N) A/T 7075-T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES, SAWED. AMS-QQ-A-250/12 IS 2007 EXC_MRK AMS-STD-2154 IS 2010 EXC_MRK AMS4078 REV G EXC_MRK ASTM209 REV 10 EXC_MRK BSS7055 REV A EXC_MRK MMS159 REV P ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-40 % USI CL A 3 MM CQR 0231073 REV 02 CUST REQ 11-09-27 *** W/E 11-10-01 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	338534	708281	3093	2	PC	47111
2	338536	708281	3093	2	PC	47111
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			10833	7		

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CQR: 0231073.2 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	57.0	6

SOLD TO

SHIPPER NO.

BY

COPPER & BRASS REPRESENTATIVE

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

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Per:

Malcolm Murphy

Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292848

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

2011-09-26

6375246

00000

1000320482-5

DS-20482-02-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

5400113144 Ln#: 0030

COPPER & BRASS SAL G041120093R04

Page 2 of 2

CQR: 0231073.2 -Specification Limits (cont.)

T7351 Elec. Cond. (EC) % MIN 38.0 PCT

Chemical Composition

SI FE CU MN MG CR ZN TI Other Other
Each Total Aluminum

Alloy 7075

Max

0.40 0.50 2.0 0.30 2.9 0.28 6.1 0.20 0.05 0.15

Lot: 708281

Min

1.2 2.1 0.18 5.1

REMAIN

- Mechanical, Physical, Metallography, Quantometer Results

Temp

Dir

No->

UTS

TYS

EL4D

T7351

Long Transv.

Test

KSI

KSI

PCT

3

71.4

60.8

10.6

71.3

60.7

10.5

71

60.3

10.5

T7351 Elect Cond %IACS 41.2 41.5 41.3 PCT

Cast Number

Chemical - OBS

SI

FE

CU

MN

MG

CR

ZN

TI

H9370105

Actuals

0.08

0.30

1.6

0.02

2.5

0.18

5.6

0.02

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